

ABSTRACT OF THE DISCLOSURE

IMPROVED CASTING PROCESS FOR TOILET BOWLS

5 The present invention provides an improved system and method for casting
toilets. In the disclosed method, at least one of a shell, engine and rim configuration for a
toilet is provided, wherein the configuration is selected from a plurality of shell, engine
and rim configurations defined by a corresponding plurality of shell, engine and rim
molds. Each mold defines a casting space therewithin for casting the selected
10 configuration therefrom. Each shell configuration includes a hollow housing space for
disposition of a unique sanitaryware performance engine configuration therewithin.
While still greenware, the cast engine is disposed in the shell housing space to form at
least one shell and engine assembly thereby. Subsequently, and while also in a green
state, the cast rim is assembled with the shell and engine assembly and the entire shell,
15 engine and rim assembly is fired to form a single integral piece of sanitaryware. In the
corresponding system, a series of casting stations is provided that defines a casting
sequence, wherein each said station performs a specific casting step. The selected
configuration is sequentially directed to at least one station selected from the series of
stations where at least one casting step is performed. Sequential direction and casting
20 steps are repeated until a predetermined number of toilets are produced.